

Work Order ID 77948

December-23-11 10:25:07 AM

77948

Page 1

Item ID: D206-642-151

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Replacement Skidtube

Stop *NS2*

Start Date: 22/12/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 01/02/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/12/23 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr .	Revision Nbr								
D3804	A								
IIN-D206-642	O								

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per RFP D206-642-151

CHG001

SCRAP

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng./ Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D206-642-151

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N900040100

Setup Start *NS1*

Revision ID:

Item Name: Replacement Skidtube

Stop *NS2*

Start Date: 22/12/2011 Start Qty: 1.00

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Required Date: 01/02/2012 Req'd Qty: 1.00

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.00							
Skidtubes	1-Deburr Fwd edge of tube								
	2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804								
	3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required. Pick: Qty Part Number Description Batch A/R Aluminum Rod M119712/M119785								
	4-Grind weld flush to cap on top surface only.								
	5-Cut Aft end as per dwg D3804 from front of tube and Deburr								
	6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804								
	7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.								
	8-Drill pilot holes using Dt8166 & DT8169D & DT9771.								
	9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.								
	10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.								

> MB/B 12-1-25

> RM DP

12-1-27
12-1-30
12-1-27

MB 12/01/30
DL 12/01/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.

****no wearplate holes for this skidtube****

17-Deburr tube and blow out chips from inside the tube

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

MD 12/01/30
DC 12/01/30

P/b →

Dart Aerospace Ltd

W/O: 11948		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D706-642-157 PAR #: Fault Category: Landing Gear / Skid tube NCR: Yes No DQA: OK Date: 12/2/3

Resolution: Scrap Disposition: SCRAP QA: N/C Closed: OK Date: 12/3/2

NCR: 1175		WORK ORDER NON-CONFORMANCE (NCR) 1525.83						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/01/30	110	Qty +5 holes in one side are ovalized + elongated. R.C. Process. (Drilling through Salt mat to hard)	<u>OK</u> 12/01/30 057012	Scrap + Destroy no Penke. Qty +1	<u>OK</u> 12-2-2	<u>OK</u> 12/02/02	<u>OK</u> 12/01/30 057012	<u>OK</u> 12/01/30

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Item ID: D206-642-151

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube

Stop ***NS2***

Start Date: 22/12/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 01/02/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QS1005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									
160		0.00							
160									
Skidtubes	Skidtubes	0.00							
Skidtubes	Memo								
Skidtubes	1-Open holes to finished size as per Dwg D3804, (without cutting fluid)								
	2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)								
	3-Deburr and blow out all chips from inside the tube								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 22/12/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 01/02/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170 QC6- Inspect dimensions to drawing

0.00

170

QC

Memo

0.00

Quality Control

180

0.00

180

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

2-Bond D2654-1 web in place as per QSI 015. Ensure holes line up.Allow 12 Hrs. cure time before cutting

Start Date: _____ Time: _____

Finish Date: _____ Time: _____

Pick:

Qty Part NumberDescriptionBatch

A/RSikaflex-291 _____

Sikaflex expire date: _____

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop ***NS2***

Cust Item ID:

*** 1 ***

1

Customer:

Run Start *NR1*

Stop *NR2*

NR2

**Insp.
Stamp**

0.00

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 77948***77948***

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Item ID: D206-642-151

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube

Stop ***NS2***

Start Date: 22/12/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 01/02/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200		0.00							
200	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-remove alodine from around hole and prepare for welding								
	2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. Pick: QtyPart NumberDescriptionBatch A/RAluminum Rod _____								
	3-Grind welds flush as per Dwg D3804.								
	4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required. A/RSS Rod _____								
	5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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December-23-11 10:25:08 AM

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Stop *NS2*

Cust Item ID:

Start Date: 22/12/2011 **Start Qty:** 1.00

1

Customer:

Required Date: 01/02/2012 **Req'd Qty:** 1.00

*** 1 ***

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210	0.00
-----	------

210

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

Install D2680-041 Nut Plate as per Dwg D3804

215	QC9- Inspect visual per QSI004- Fusion Welds	0.00
-----	--	------

215

QC

Memo

0.00

Quality Control

220	QC10- Inspect visual per QSI004- ground welds	0.00
-----	---	------

220

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

December-23-11 10:25:08 AM

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Replacement Skidtube

Start Date: 22/12/2011 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 01/02/2012 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------

230

QC	Memo	0.00
----	------	------

Quality Control

240	Pressure Wash per QSI005 4.3	0.00
-----	------------------------------	------

240

HandFinish	Memo	0.00
------------	------	------

Hand Finishing

250	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00
-----	--	------

250

Powdercoat	Memo	0.00
------------	------	------

Powder Coating

START TIME: _____
OVEN TEMPERATURE: _____
FINISH TIME: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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1

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC3- Inspect Part Finish	0.00							
260									
QC	Memo	0.00							
Quality Control									
270	HandFinishing	0.00							
270									
HandFinish	Memo	0.00							
Hand Finishing	1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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N900040100

Setup Start *NS1*

Stop ***NS2***

Cust Item ID:

*** 1 ***

*** 1 ***

Customer:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

HandFinishing

0.00

Memo

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive
A/RSikaflex-291 _____
Sikaflex expire date: _____

2- Install wearplate as per dwg

2-Wing Walk as per Dwg D3804 and QSI 005 4.4 Batch:

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300	QC5- Inspect part completeness to step on W/O	0.00							
300									
QC	Memo	0.00							
Quality Control									
310	Packaging	0.00							
310									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-151 Location: _____ PPP Rev: _____								
320	QC21- Final Inspection - Work Order Release	0.00							
320									
QC	Memo	0.00							
Quality Control									

MF
12-02-02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Picklist Print

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Work Order ID: 77948

77948

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 22/12/2011

Required Date: 01/02/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV.N DD VERF:EC IPP
REV:B 11.09.16 PER IIN REV.O DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2620		Manufactured	No			110	Each	13.0000	1	1			
D2620													
Skidtube, 206 Skidtube													
					<u>Location</u>	<u>Loc Qty</u>							
					LG	13							
					71616	3							
					71617	6							
					75470	2							
					75587	2							
D2647		Manufactured	No			110	Each	183.0000	1	1			
D2647													
Cap													
					<u>Location</u>	<u>Loc Qty</u>							
					LG002	183							
					73826	74							
					75482	109							

**

25-1-12

**

BE 12-01-25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 22/12/2011

Required Date: 01/02/2012

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-04

Purchased

No

180

Each

12,557.00

52

52

CR3212-4-04

Cherry Rivet

Location

Loc Qty

Loc Code

ST331

2567

116471

78

117816

3

118686

1

118840

16

119017

2459

119075

10

st510

9990

119075

9990

D2654-1

Manufactured

No

180

Each

0.0000

1

1

D2654-1

Web

B77279/B77281

per LL 12/2/9

D3286-1

Manufactured

No

180

Each

178.0000

2

2

D3286-1

Doubler

12/01/238

Location

Loc Qty

Loc Code

LG002

178

74872

6

75484

54

(2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-23-11 10:25:12 AM

Page 3

Work Order ID: 77948

77948

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 22/12/2011

Required Date: 01/02/2012

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

200

Each

634.0000

19

19

D2649

Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG001

634

65317

1

68224

2

68507

11

71355

2

72704

2

72841

11

73390

8

73857

21

73858

53

73859

4

73860

4

76793

515

D3286-3

Manufactured No

200

Each

18.0000

2

2

D3286-3

Spacer

Location

Loc Qty

Loc Code

LG001

1

74117

1

LG002

17

75483

17

D2680-041

Manufactured No

210

Each

64.0000

1

1

D2680-041

Nut Plate

Location

Loc Qty

Loc Code

ST020

64

75479

64

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 4

December-23-11 10:25:12 AM

Work Order ID: 77948

77948

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 22/12/2011

Required Date: 01/02/2012

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

210

Each

1,762.000

2

2

CR3212-4-03

Cherry Rivet

Location

Loc Qty

Loc Code

FP002

768

114859

768

ST331

994

110139

2

119017

992

AN960JD416

NAS1149D0463J

Purchased

No

210

Each

0.0000

1

1

AN960JD416

Washer

CCR264SS3-3

Purchased

No

210

Each

993.0000

2

2

CCR264SS3-3

Cherry Rivet

Location

Loc Qty

Loc Code

ST331

993

113973

2

117849

147

119017

844

MS27039-4-06

Purchased

No

210

Each

323.0000

1

1

MS27039-4-06

Screw

Location

Loc Qty

Loc Code

ST292

323

119075

323

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Page 5

December-23-11 10:25:12 AM

Work Order ID: 77948

77948

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 22/12/2011

Required Date: 01/02/2012

Start Qty: 1.00

Required Qty: 1.00

D2651-1 Manufactured No 270 Each 357.0000 6 6

D2651-1

Plug

Location

Loc Qty

Loc Code

FP001

357

57869

1

66445

10

69018

2

70839

2

71037

31

73827

311

D2651-3 Manufactured No 270 Each 847.0000 6 6

D2651-3

O-Ring

Location

Loc Qty

Loc Code

FP001

847

61962

12

73828

835

D3873-1 Manufactured No 280 Each 611.0000 14 14

D3873-1

Bushing

Location

Loc Qty

Loc Code

ST088

611

64760

1

68247

4

73829

19

73830

2

76792

585

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 77948

77948

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 22/12/2011

Required Date: 01/02/2012

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

280

Each

153.0000

1

1

D2646

Aft Cap

Location

Loc Qty

Loc Code

FP002

153

62678

5

68280

5

70945

1

71038

4

71070

2

73294

1

73825

135

D3805-041

Manufactured No

280

Each

1.0000

1

1

D3805-041

Wearplate Assembly Fwd, Low Gear

Location

Loc Qty

Loc Code

FP001

1

75149

1

MS27039-1-08

Purchased No

280

Each

1,243.000

2

2

MS27039-1-08

Screw

Location

Loc Qty

Loc Code

ST291

1243

117423

77

118910

226

119075

440

119109

500

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

December-23-11 10:25:12 AM

Page 7

Work Order ID: 77948

77948

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 22/12/2011

Required Date: 01/02/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

280

Each

6,837.000

7

7

MS21042L3

Nut

Location

Loc Qty

Loc Code

ST300

6837

117441

16

117885

32

118451

5

118927

3

119017

5988

119075

793

D3805-045

Manufactured

No

280

Each

2.0000

1

1

D3805-045

Wearplate Assembly Aft, Low Gear

Location

Loc Qty

Loc Code

FP001

2

73817

1

74896

1

AN960JD10L

NAS1149D0332J

Purchased

No

280

Each

0.0000

2

2

AN960JD10L

Washer

AN3-37A

Purchased

No

280

Each

1,546.000

7

7

AN3-37A

Bolt

Location

Loc Qty

Loc Code

ST353

1546

117619

4

119086

1542

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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December-23-11 10:25:12 AM

Page 8

Work Order ID: 77948

77948

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 22/12/2011

Required Date: 01/02/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

280

Each

2,252.000

7

7

NAS1149D0363.I

Washer

Location

Loc Qty

Loc Code

ST298

2252

117601

61

118077

1

118612

18

118968

137

119537

2035

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 77948 M.L.J

11/12/23

RELEASED
UP 09.03.03
PC ECN 09-590

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	91		
DRAWN	91		
CHECKED	91		
MFG. APPR.	91		
APPROVED	91		
DE APPR.	91		
DATE	08.07.07		

DART AEROSPACE USA, INC	
PORT HADLOCK, WA	
DRAWING NO.	REV. A
D3804	SHEET 1 OF 5
TITLE	SCALE
SKIDTUBE ASSEMBLY, 206A/B	NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

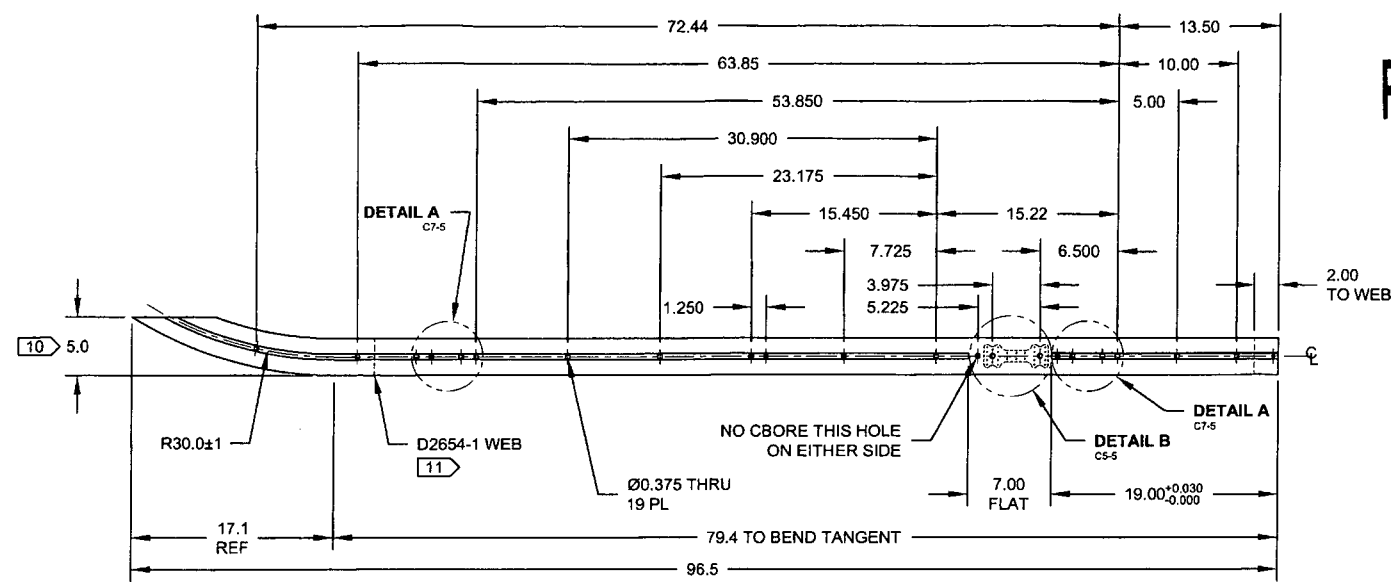
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

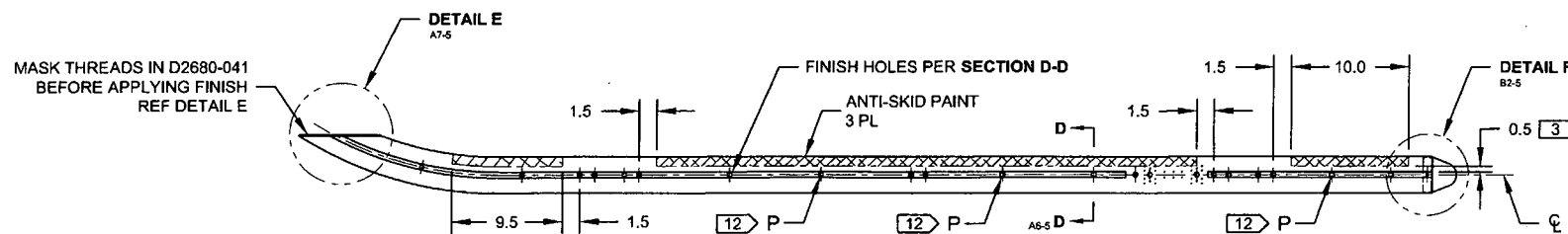
NOTE: Date & initial all entries

77948

RELEASED
09.03.03



D3804-041 BENDING/DRILLING DETAIL



D3804-041 ASSEMBLY/FINISHING DETAIL

DESIGN	99	DART AEROSPACE USA, INC	
DRAWN	99	PORT HADLOCK, WA	
CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.	99	D3804	SHEET 2 OF 5
APPROVED	99	TITLE	SCALE
DE APPR.	99	SKIDTUBE ASSEMBLY, 206A/B	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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09-03-03



DESIGN	99	DART AEROSPACE USA, INC	
DRAWN	JD	PORT HADLOCK, WA	
CHECKED	JD	DRAWING NO.	REV. A
MFG. APPR.	BE	D3804	SHEET 3 OF 3
APPROVED	JD	TITLE	SCALE
DE APPR.	JD	SKIDTUBE ASSEMBLY, 206A/B	NTS
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

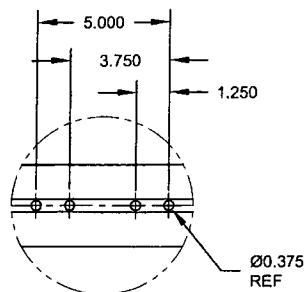
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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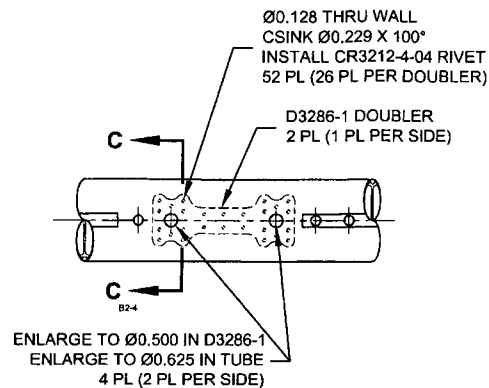
77948

RELEASED
CP 09.03.07



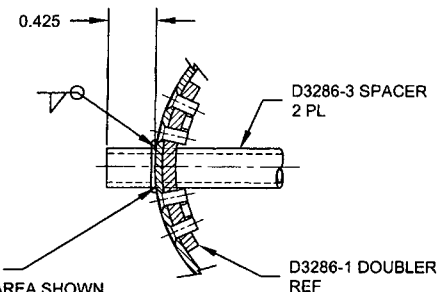
DETAIL A
SCALE NONE

D6-2
C2-2
D6-3
C2-3



DETAIL B
SCALE NONE

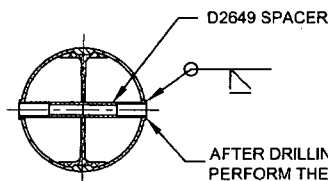
C3-2
C3-3



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C
PARTIAL SECTION
SCALE NONE

C6-4



- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

SECTION D-D
FOR Ø0.375 HOLES ONLY
SCALE NONE

A4-2
A4-3

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 4 OF 5
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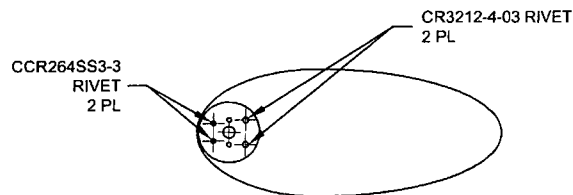
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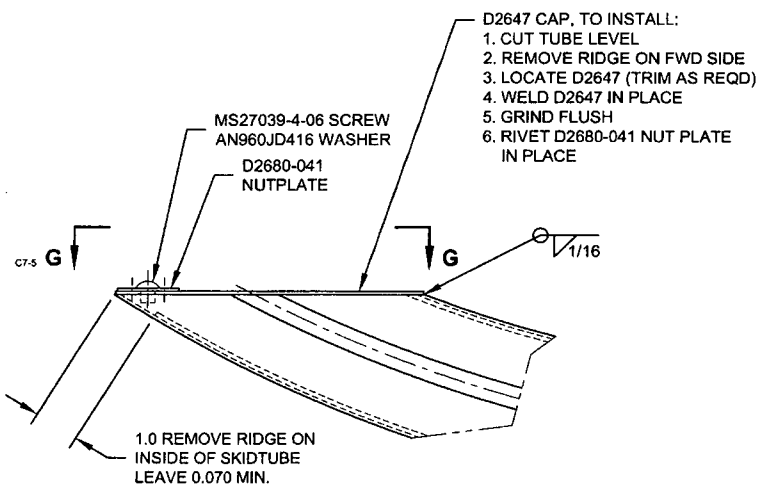
77948

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99 09.03.03



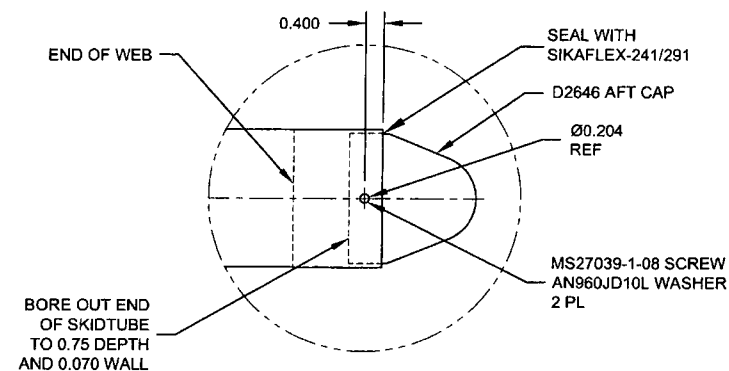
VIEW G-G
SCALE NONE

A7-5



DETAIL E
SCALE NONE

B7-2
B7-3



DETAIL F
SCALE NONE

B2-2
B2-3

DESIGN	99	DART AEROSPACE USA, INC	
DRAWN	99	PORT HADLOCK, WA	
CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.	99	D3804	SHEET 5 OF 5
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Kim Johnston

From: Linda Lacelle <llacelle@dartaero.com>
Sent: Thursday, February 09, 2012 10:51 AM
To: Kim Johnston
Subject: 77948 - D206-642-151

The B/N's for the D2654-1 web's got mixed up on two batches – 77279 & 77281, so I have added both b/n's to all the w/o's affected. 77948 is already canned, can you pls correct:
77279/77281



Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd
Hawkesbury, ON
Phone: 613 632 9577
Fax: 613 632 1053
Cell: 613 676 1655